

Work Order ID 64769

December 16, 2010 1:23:03 PM



Page 1

Item ID: D2804-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 12/16/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/17/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Handwritten signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2804	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per File D2804-1-2_BLANK

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

~~10/12/15~~

10-9-15

10-12-16

(4)

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA103

ack 10/12/15

~~10-9-15~~

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ack 10/12/15

4

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Item ID: D2804-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 12/16/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/17/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>G.A</i>	<i>10/12/16</i>		<i>4</i>	<i>0</i>		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	<i>⇒ JH</i>	<i>10/12/20</i>		<i>4</i>	<i>0</i>		
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>H</i>	<i>BL</i>	<i>10-12-20</i>	

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Item ID: D2804-2

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 12/16/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/17/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location: G-A

0.00

Memo

w/o 66643

0.00

EP 11/02/23

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/02/23

MF
11-02-23

Picklist Print

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Page 1

Work Order ID: 64769



Parent Item: D2804-2



Parent Item Name: Bracket

Start Date: 12/16/10

Required Date: 12/17/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 00.11.06 New Issue EC
 IPP B 06.05.30 Blanks on wjet EC
 IPP Rev: C As per Rev C 06-11-09 JLM
 IPP Rev: D Removed Tumbling 08-09-10 JLM Verified By: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X10.00 0		Purchased	No				f	14.0000	0.75	3			



6061-T6 Bar .500 x 10.00



1810-12-16
 1810-12-16

(4)

Location

Loc Qty

Loc Code

MAT05

14

111382

2

112764

12

111382

DART AEROSPACE LTD		Work Order:	62546 4769
Description: Bracket		Part Number:	D2804-1
Inspection Dwg: D2804	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø.760	✓		Micr	ML-01
Ø0.191	+0.005/-0.001	Ø.193	✓		Vern	ML-7
1.420	+/-0.001	1.419	✓		"	"
Ø0.507	+0.000/-0.001	Ø.5069	✓		Micr	ML-01
0.250 deep	+/-0.010	.251	✓		Vern	ML-7
Ø0.507	+0.000/-0.001	Ø.507	✓		Micr	ML-01
Ø0.191	+0.005/-0.000	Ø.193	✓		Vern	ML-7
6.933	+/-0.010	6.933	✓		M-type	ML-2
7.578	+/-0.010	7.578	✓		"	"
12.304	+/-0.010	12.304	✓		"	"
0.125	+/-0.010	.126	✓		Vern	ML-7
0.500	+/-0.010	.502	✓		"	"
0.125	+/-0.010	.123	✓		"	"
0.250	+/-0.010	.250	✓		"	"
0.875	+0.000/-0.001	.8748	✓		Micr	ML-01
0.250	+0.000/-0.005	.250	✓		Depth-gage	ML-05

Measured by:	<i>mf</i>	Audited by:	H.A	Prototype Approval:	N/A
Date:	10/12/15	Date:	10/12/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.06.05	Removed dimensions 12.625, 0.608, 0.437, 2.654	KJ/EC	
C	06.11.10	Revised per drawing revision C	KJ/JLM	
D	09.03.10	Tolerance revised for Ø0.757	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

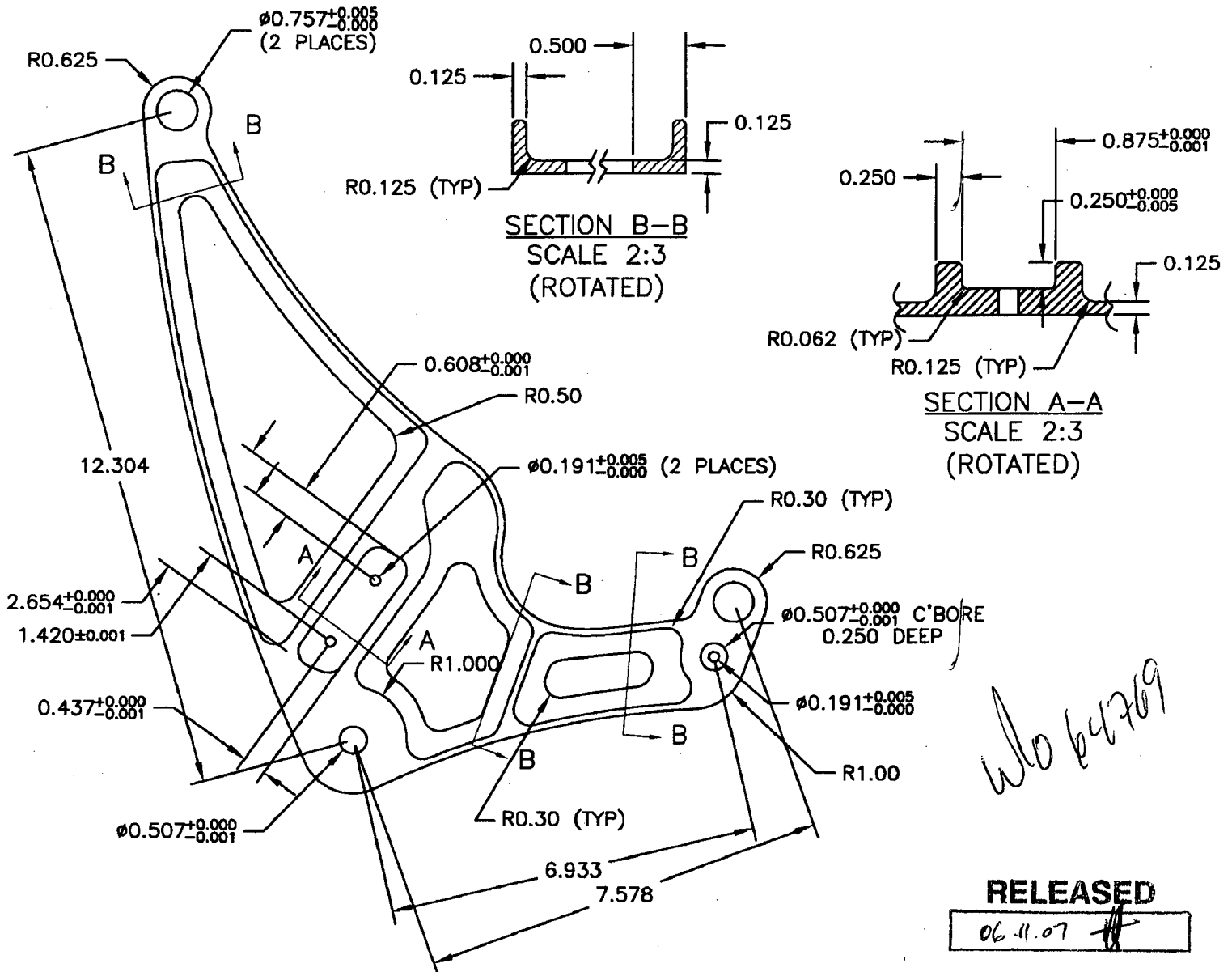
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

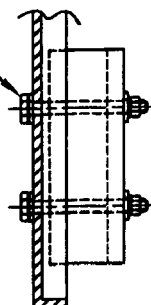
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21042-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



USE D2804-1 FOR D2804-041/-043
USE D2804-2 FOR D2804-042/-044

SECTION C-C
SCALE 1:3
(ROTATED)

USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
USE D2805-3 FOR D2804-043
USE D2805-4 FOR D2804-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

[Handwritten signature]
RELEASED

06.11.07 *[Signature]*

D2804-041/-043 BRACKET ASS'Y (SHOWN)

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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